Date: Thursday, 15/03/2007 10:53:51 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BACKING PLATE
Job Number	: 31237			
Estimate Number	: 10506			
P.O. Number	: N/A		Part Number	: D2228
This Issue	: 15/03/2007 S.O. No. : N/A		Drawing Number	: D2228 REV. B
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS		Drawing Revision	: B
Previous Run	: 31157		Material	: N/A
Written By	:		Due Date	: 22/03/2007 Qty: 15 10 Um: Each
Checked & Approved By	:			
Comment	: Est:B 00.08.22 Re-format EC			

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S063	5052-H32 .063 Sheet

Comment: Qty.: 0.0227 sf(s)/Unit Total : 0.2270 sf(s)   X 16 (0.3632) sf
5052-H32 .063 Sheet
Material: 5052-H32 Sheet (QQ-A-250/8) 0.063" thick
(M5052H32S.063) Batch: M19296   ml 07/03/15

2.0	SHEAR	SHEAR

Comment: SHEAR
Cut blank: 1.710" x 1.920"   ml 07/03/15

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr — Holes as per drwng   x16   ml 07/03/15

4.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP   SB 07/03/15 16

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

15x

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1   M-h   07/03/16

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: _____ Date: 07/03/19

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services	**Drawing Name:** BACKING PLATE
Job Number: 31237	**Part Number:** D2228

Job Number:

Seq. #:	Machine Or Operation:	Description :

6.0   POWDER COATING   POWDER COATING

M103706   (16)

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3   *m.l*   07/03/16

7.0   QC3   INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION   *SB*   07/03/16   (16)

8.0   PACKAGING 1   PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *G A*   *SB*   07/03/16   (16)

9.0   QC21   FINAL INSPECTION/W/O RELEASE

   (16)

Comment: FINAL INSPECTION/W/O RELEASE   *D 07/03/19*

Job Completion   *U 07.03.19*

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action	Section B				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

DRAWN	**DART AERO ACCESSORIES INC**	
BRADLEY 94.2.23	VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN	DRAWING NO.	REV. B
BRADLEY 94.2.23	D2228	SHEET 1 OF 1
STRESS	TITLE BACKING PLATE	
B	00.09.11	UPDATE FINISH SPEC. ∄ CP

DART

QA COPY ISSUED

RELEASED
00.09.12 ∄

1.710

1.410

.300

.300

1.620

1.920

.125 RAD
(TYP)

.171 DIA
4 HOLES
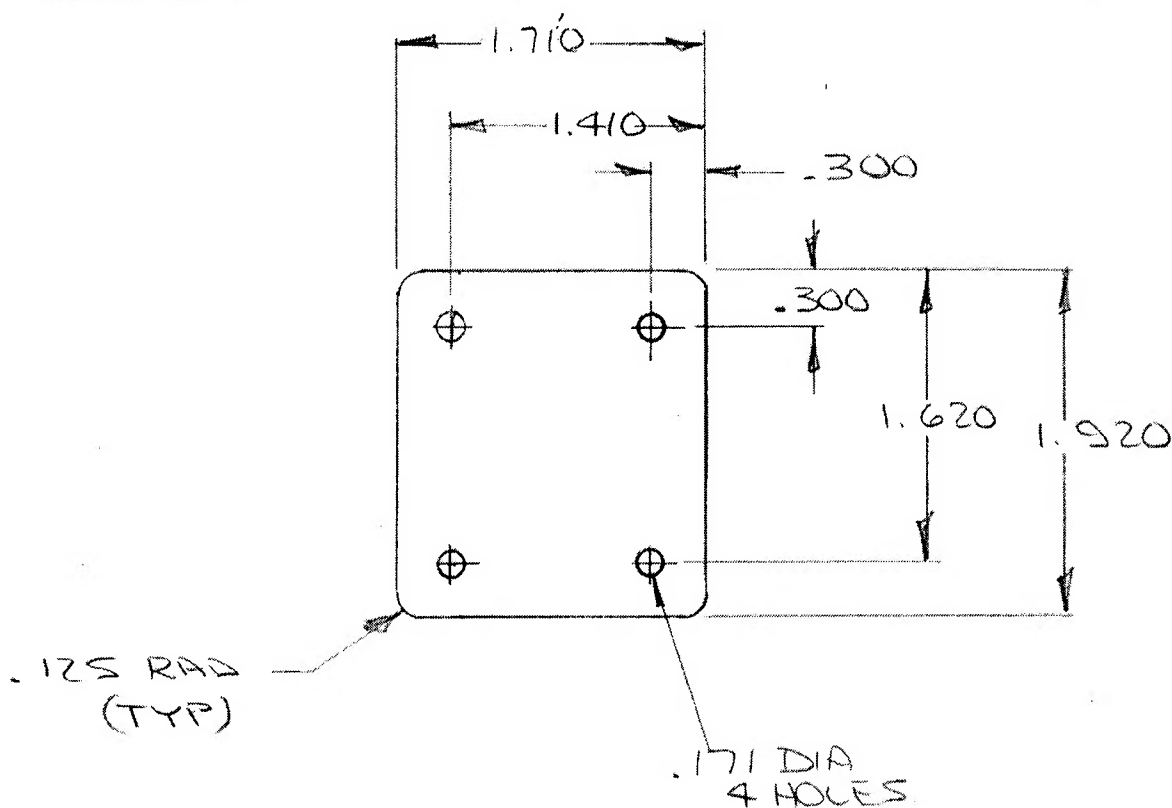
MATERIAL :   5052-H32   .063 THICK
(QQ-A-250/8)

FINISH :   /B\ CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

W/O 31237

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:								
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:								
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries